

**Work Order ID 80099****\*80099\***

Page 1

Item ID: D3137-045

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket Assembly

Start Date: 09/02/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: M.C.J.Date: 12/02/10

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3137	Rev F

100

**\*100\***

BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (.500" x 2.000") 4.400" long

OK 12/02/174

110

**\*110\***

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3137-9 as per Folio FA621 and Dwg D3137 Identify as D3137-92-Deburr3-Scribe batch number

OK 12/02/044

120

**\*120\***

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

OK 12/03/044

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80099**

February-09-12 4:31:45 PM

**\*80099\***

Page 2

Item ID: D3137-045

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket Assembly

Start Date: 09/02/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

SL 12-03-05

**\*130\***

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

**\*140\***

Small Fab

Memo

0.00

Small Fab

Assemble D3137-045 as per Dwg D3137

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

5/2/06

12/03/06 (4)

(2)

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February-09-12 4:31:45 PM

\*80099\*

Page 3

Item ID: D3137-045 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bracket Assembly  
 Start Date: 09/02/2012 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 23/02/2012 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>236B</u>	0.00							
*160*									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
*170*									
QC	Memo	0.00							
Quality Control									

12/3/6  
 1203-6  
 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

February-09-12 4:31:48 PM

Page 1  
2

Work Order ID: 80099

\*80099\*

Parent Item: D3137-045

\*D3137-045\*

Parent Item Name: Bracket Assembly

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A04.02.18New issueKJ/DS  
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS24694-S101

Purchased

No

100

Each

29.0000

1

4

\*MS24694-S101\*

Screw

\*\*

EP 12/03/06

Location

Loc Qty

Loc Code

ST289A

14

118159

9

119638

5

ST290A

15

120498

15

D3137-3

Manufactured

No

140

Each

5.0000

1

4

\*D3137-3\*

Guide

\*\*

EP 12/03/06

Location

Loc Qty

Loc Code

ST235A

5

76873

5

D3137-5

Manufactured

No

140

Each

17.0000

1

4

\*D3137-5\*

Washer

\*\*

B 79735  
EP 12/03/06

Location

Loc Qty

Loc Code

ST235A

17

46740

3

77022

14

4

W/O:		WORK ORDER CHANGES					
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February-09-12 4:31:48 PM

Page 2

Work Order ID: 80099

Parent Item: D3137-045

Parent Item Name: Bracket Assembly

\*80099\*

\*D3137-045\*

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 4.00

Required Qty: 4.00

M174B0.500X02.000

Purchased

No

140

f

44.8771

0.3666

1.543579

\*M174B0 500X02 000\*

\*\*

17-4 SS Bar .500 x 2.00

Location

Loc Qty

Loc Code

MAT050

44.8771

100843

8.012

103089

13

14932

18.9051

19572

4.96

1.55 OK 12/02/12

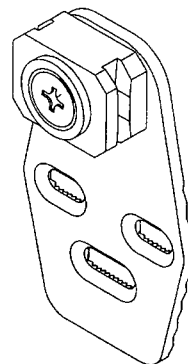
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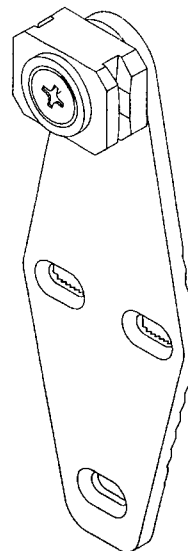
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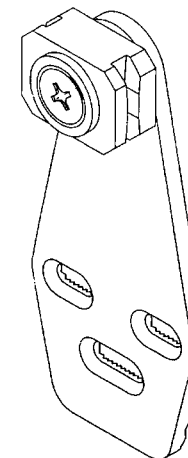
**NOTE:** Date & initial all entries



**D3137-041 BRACKET ASSEMBLY**



**D3137-043 BRACKET ASSEMBLY**



**D3137-045 BRACKET ASSEMBLY**

SEE  
UNCL  
800 99 M.L.J  
12/02/10

F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A 5 DIM 2.36 WAS 2.48. ZONE A 4 0.480 DIM WAS 0.605. ZONE A 9 0.67 DIM WAS 0.79. ZONE B 5 4.850 DIM WAS 4.975 & ZONE B 8 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	AJS	08.05.30
E	ADD -045	RF	05.11.23
D	RE-DESIGN D3137-5; CHANGE DIMS	DS	04.11.03
C	ADD -043	DS	03.08.15
B	ADD RIDGES; ADD MATERIAL PROP	DS	03.01.16
A	NEW ISSUE	DS	02.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 1 OF 5
APPROVED		TITLE	SCALE
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

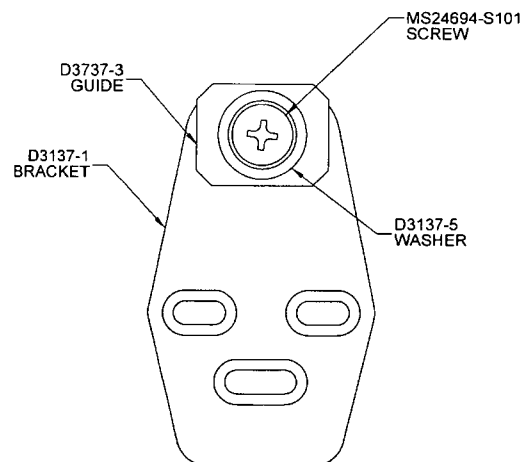
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

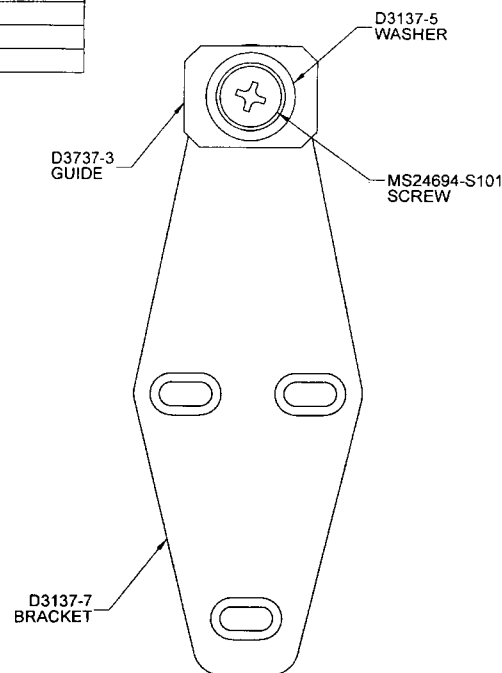
**NOTE:** Date & initial all entries

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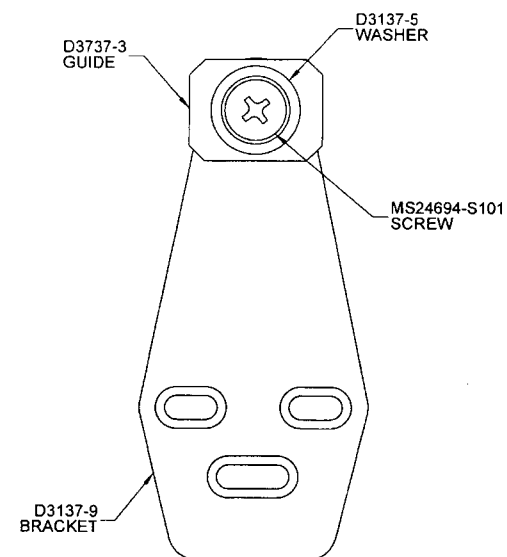
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



**D3137-041 BRACKET ASSEMBLY**



**D3137-043 BRACKET ASSEMBLY**



**D3137-045 BRACKET ASSEMBLY**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.18 lbs -041  
: 0.32 lbs -043  
: 0.27 lbs -045

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28-06-26/11

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. <b>D3137</b>	REV. F
MFG. APPR.		TITLE <b>BRACKET ASSEMBLY</b>	SCALE NTS
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DATE	08.05.30		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

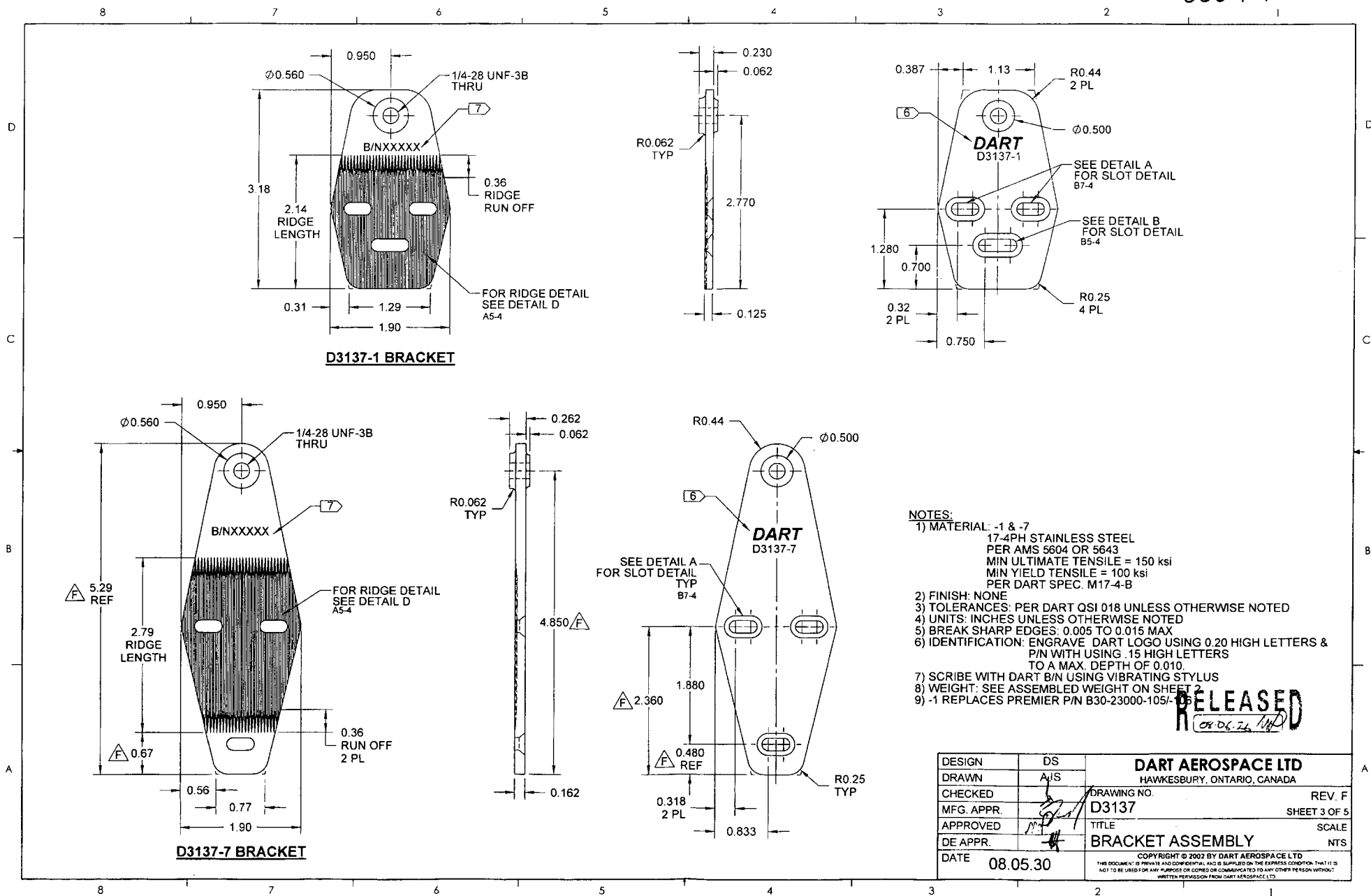
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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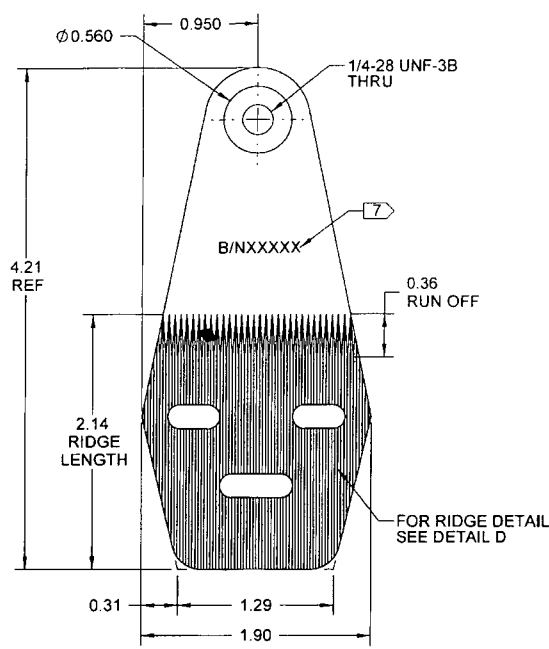
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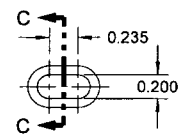
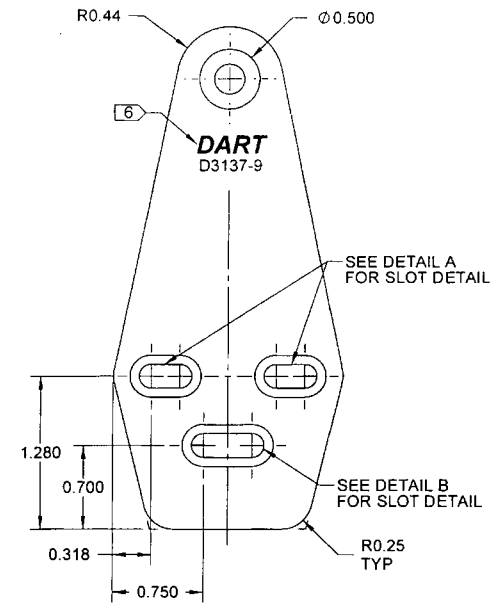
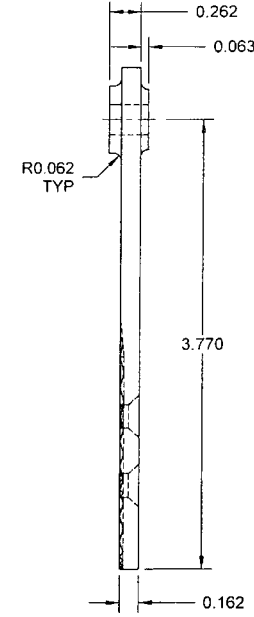
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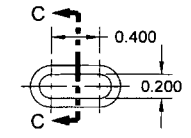
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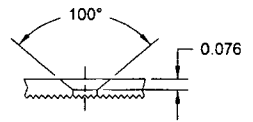
**D3137-9 BRACKET**



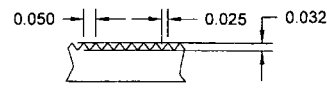
**DETAIL A  
(SLOT DETAIL)**



**DETAIL B  
(SLOT DETAIL)**



**SECTION C-C  
(SLOT DETAIL)**



**DETAIL D  
SCALE 2X  
(TYPICAL RIDGE DETAIL)**

- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi  
PER DART SPEC. M17-4-B
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.020 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
  - 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
  - 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
  - 9) REPLACES PREMIER P/N B30-23000-105/-106

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
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08-05-30

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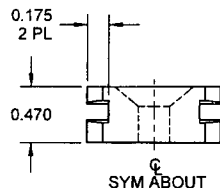
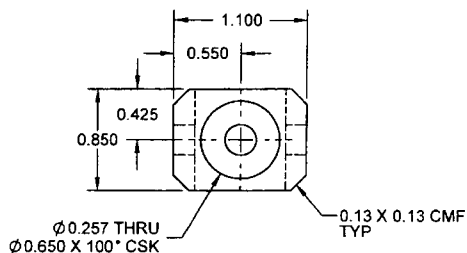
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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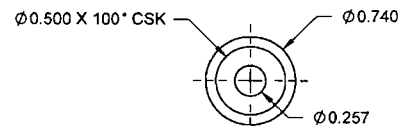
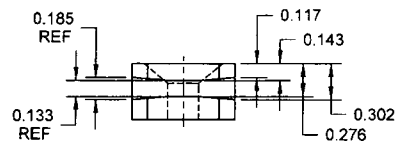
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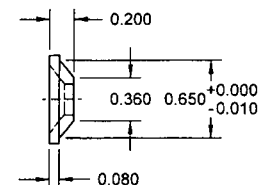
80099



**D3137-3 GUIDE**



**D3137-5 WASHER**



**NOTES:**

- 1) MATERIAL: -3  
DELTRIN II 150E OR ACETRON GP ACETAL, BAR  
(REF DART SPEC M-DELTRIN-B)
- 5  
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR  
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)  
OR PER-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207  
-5 REPLACES PREMIER P/N B30-2300-209

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DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 5 OF 5
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80099
<b>Description:</b> Bracket		<b>Part Number:</b>	D3137-9
<b>Inspection Dwg:</b> D3137 <b>Rev:</b> F		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.435	+/-0.010	.435	—		U <sub>dim</sub> ML-06	
0.615	+/-0.010	.620	—			
0.200	+/-0.010	.204	—			
0.600	+/-0.010	.600	—			
0.780	+/-0.010	.784	—			
0.500	+/-0.010	.505	—			
0.063	+/-0.010	.061	—			
R0.062	+/-0.010	R.062	—			
0.162	+/-0.010	.164	—			
Ø0.560	+0.008/-0.001	Ø.560	—			
4.21	+/-0.030	4.208	—			
3.770	+/-0.010	3.767	—			
1.280	+/-0.010	1.280	—			
0.700	+/-0.010	.700	—			
1.90	+/-0.030	1.892	—			
100°	+/-0.5°	100°	—			
2.14	+/-0.030	2.170	—			
0.262	+/-0.010	.264	—			
R0.25	+/-0.030	R.250	—			
0.032	+/-0.010	.029	—			

<b>Measured by:</b>	<i>am</i>	<b>Audited by:</b>	<i>sk</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	12/03/04	<b>Date:</b>	12-03-05	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue      P/O D3137-045	KJ/JLM	
B	08.12.02	Dwg Rev updated	KJ/DD	
C	09.10.16	Dimension 0.380 & 0.595 removed	KJ	<i>[Signature]</i>